

Date: Wednesday, 3/12/2008 1:41:38 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEB
Job Number	: 37848		
Estimate Number	: 10195		
P.O. Number	:	Part Number	: D21741
This Issue	: 3/12/2008 S.O. No. :	Drawing Number	: D2174-1 REV E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL / MED FAB	Drawing Revision	: E
Previous Run	: 31689	Material	:
Written By	:	Due Date	: 3/31/2008 Qty: 10 Um: Each
Checked & Approved By	: <u>JA 08 03 12</u>		
Comment	: Est C 04.06.09 Reformat KJ/RF Est Rev:D As per Rev E 06-11-22 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S063	2024-T3 .063 sheet
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Comment: Qty.: 0.4958 sf(s)/Unit Total : 4.9581 sf(s)

Material: 2024-T3 (QQ-A-250/4) 0.063" thick

(M2024T3S.063)

Batch: 106223 IB 8-3-14

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D2174

Dwg Rev: EProg Rev: E

IB 8-3-14

(10)

2-Deburr if necessary

IB 8-3-14

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



IB 8-3-14



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

08/03/15

(10)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr Stack

u4 Done at step #22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: P Date: 08/03/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/12/2008 1:41:38 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEB

Job Number: 37848

Part Number: D21741

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/02/09 (10)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

21 08-03-23 (10)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

10/03/09 (10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

10/03/09 (10)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

10/03/09 (10)

Job Completion



10/03/09 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	37848
Description: Web		Part Number:	D2174-1
Inspection Dwg: D2174 Rev: E		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

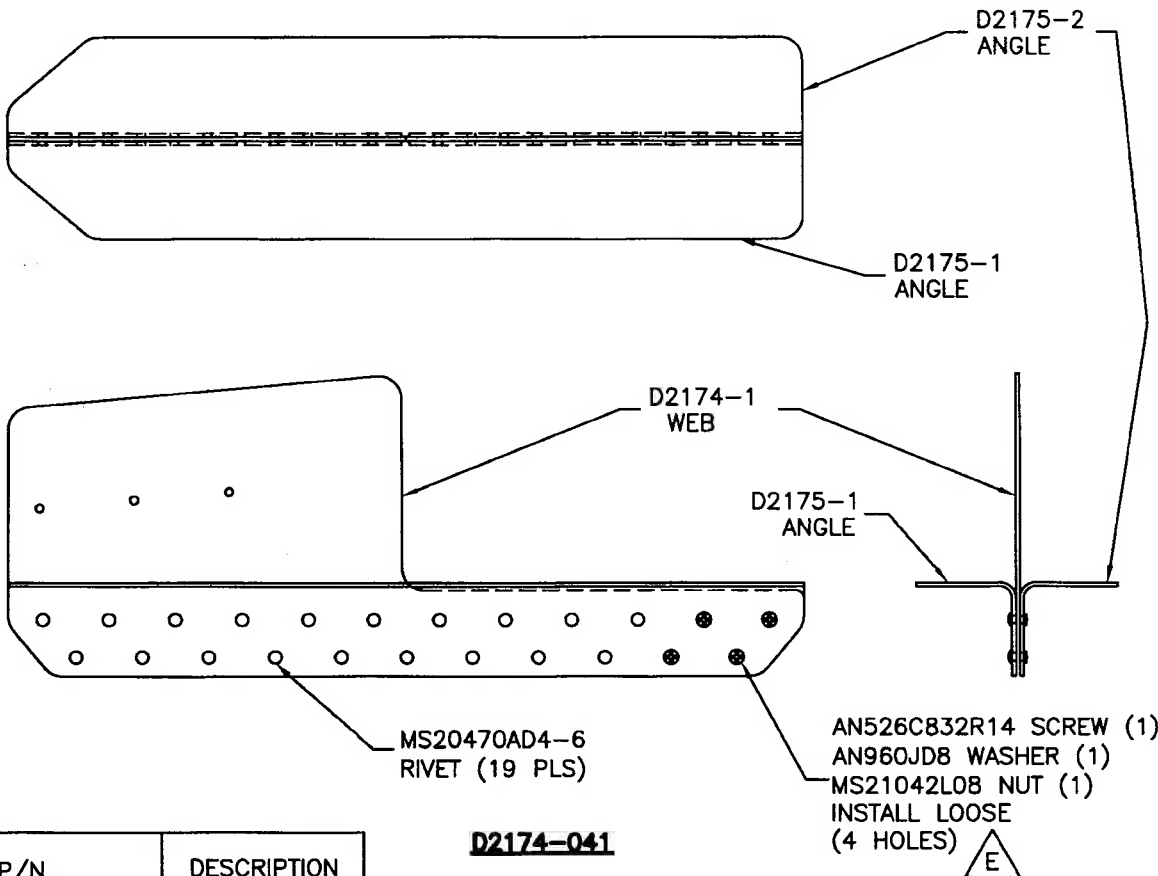
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.250	+/-0.010	6.247	*			
6.400	+/-0.010	6.400	*			
4.800	+/-0.010	4.801	*			
1.375	+/-0.010	1.374	*			
1.050	+/-0.005	1.050	*			
Ø0.128	+0.005/-0.001	.131	*			
12.650	+/-0.010	12.648	*			
0.550	+/-0.010	.548	*			
0.900	+/-0.010	.900	*			
1.629	+/-0.010	1.628	*			
1.506	+/-0.005	1.504	*			
11.550	+/-0.005	11.550	*			
50°	+/-0.5°	50°	*			
0.063 thick	+/-0.010	.063	*			
Ø0.172	+0.005/-0.001	.176	*			

Measured by:	IB	Audited by:		Prototype Approval:	N/A
Date:	8-3-19	Date:		Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	07.04.02	Ø0.172 dimension added	KJ/JLM	



DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
RF	CE	DRAWING NO.	REV. E
CHECKED PH	APPROVED CE	D2174	SHEET 1 OF 2
DATE 06.09.25		TITLE WEB ASSEMBLY	SCALE 1:3
A	95.10.25	NEW ISSUE	
B	96.01.18	RE-DRAWN	
C	00.09.11	UPDATE FINISH SPEC.	
D	04.06.03	RE-DESIGN	
E	06.09.25	INC 4 HOLES TO Ø0.172; CHG HARDWARE	



D2174-041

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
NO. 37848
WORK ORDER

QTY -041	P/N	DESCRIPTION
X	D2174-041	WEB ASSEMBLY
1	D2174-1	WEB
1	D2175-2	ANGLE
1	D2175-1	ANGLE
4	AN526C832R14	SCREW
4	AN960JD8	WASHER
4	MS21042L08	NUT
19	MS20470AD4-6	RIVET

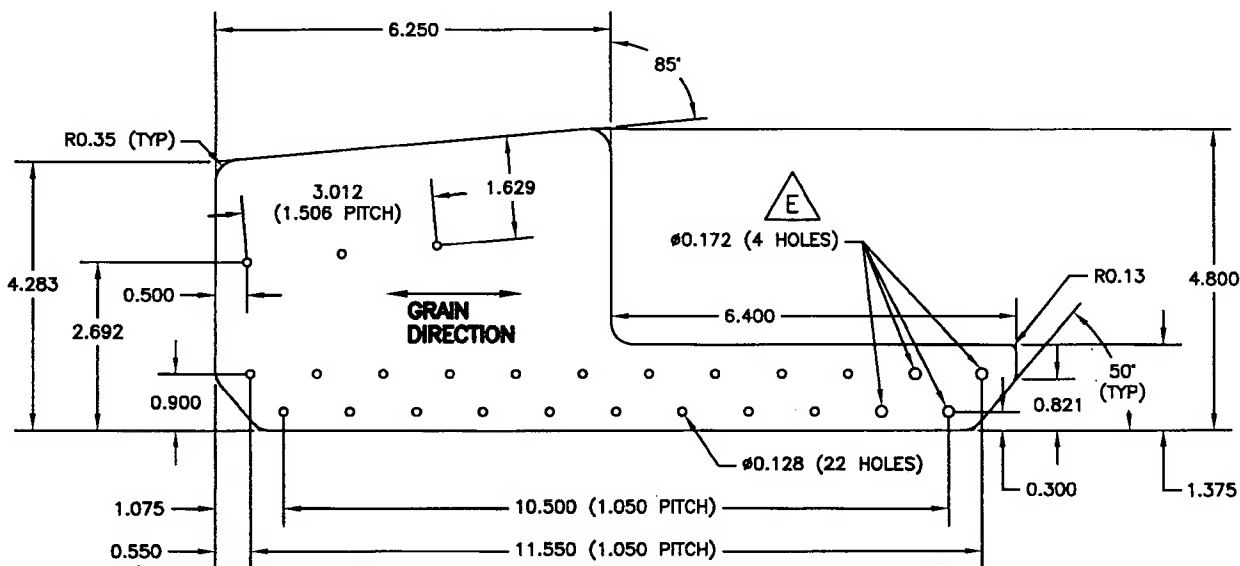
NOTES:

- 1) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) IDENTIFY WITH P/N D2174-041 USING FIND POINT PERMANENT INK MARKER.

RELEASED
06.10.13

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
RF	CE		
CHECKED	APPROVED	DRAWING NO.	REV. E
PH	[Signature]	D2174	SHEET 2 OF 2
DATE		TITLE	SCALE
06.09.25		WEB	1:3

ALL INFORMATION CONTAINED
HEREIN IS UNCLASSIFIED
DATE 06-10-03 BY 4806



D2174-1

NOTES:

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-200/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) BREAK ALL SHARP EDGES 0.005 TO 0.010
5) ALL DIMENSION ARE IN INCHES

05 TO 0010
NO
37848
WORK ORDER
SUBJECT TO AMENDMENT
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PENDING
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